



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5522-1

Job Sheet 192727



Part No: D5522-1

Job Qty: 6 pcs

Part Name: Oil Drain Valve Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/1/19

Job Tracking No:

Due Date: 4/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5522 REV.C IPP REV:A 17.05.29 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.17 MODIFY PROCESS TO MATCH INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	4/22/19	4/22/19	0.00	0.60	Bandsaw - 1		19-08-30
110	HAAS 5 Axis - B4B	6 pcs	4/22/19	4/22/19	0.00	3.00	HAAS - 5 - B4B		19-09-08
120	QC 2	6 pcs	4/22/19	4/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-09-08
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S210513



Part: D5522-1

Job No: 192727

Serial No/Batch: S210513

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/30/19

Plex 4/1/19 11:34 AM Dart.lajeunesse.marie

130 QC 8	6 pcs	4/22/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	DAS
				QC 8 - 12	14
				QC 8 - 14	9-89 <i>mk 19/09/11</i>
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Small Fab - 2 - B4B	6 pcs	4/22/19	0.00 0.60	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	58 SEP 13 2019
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	6 pcs	4/22/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	DEC 09 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Packaging 3-1 - Stock - B4B	6 pcs	4/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DEC 10 2019 DAS
				Packaging 3 - 7 - B4B	58

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	6 pcs	4/22/19	0.00 0.00	QC 21 - SA - 21	DAS	DEC 10 2010
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	9-08	

Part Op 100 - Bandsaw - Cut blanks at 3.63" -
 Descriptions: 110 - HAAS CNC vertical machine #5 - 1-Machine D5522-1 as per Folio FB540 and Dwg D5522. 2-Deburr
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Small Fab - USE ULTRA SONIC TO CLEAN D5522-1 PART MUST BE DRY INSTALL PLASTIC PUSH-ON CAPS
 150 - QC5- Inspect part completeness to step on W/O ***BEFORE PUTTING THE CAPS VERIFY IF THE PART IS CLEAN INSIDE***
 160 - Identify as per dwg & Stock Location: ST166
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.500X3.500	303 Bar 1.500" X 3.500"	1.8000 ft (.3 ea)	100-Bandsaw - 1	5154 894

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M303B1.500X3.500	2	12	0

Part Specifications

Specifications could not be found.

Plex 4/1/19 11:34 AM Dart.lajeunesse.marie

MAT
used
2.450

DART AEROSPACE LTD		Work Order: 192 727
Description: Oil Drain valve MOUNT		Part Number: D5522-1
Inspection Dwg: D5522 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/- .030	3.451	✓		SL10	Vern
2.35	+/- .030	2.350	✓			
3.35	+/- .030	3.346	✓			
2.00	+/- .030	2.000	✓			
1.25	+/- .030	1.248	✓			
R.63	+/- .030	.630	✓		Rad gauge	
.94	+/- .030	.940	✓		SL10	
.80	+/- .030	.800	✓		"	
.80	+/- .030	.800	✓		"	
R.13	+/- .030	.130	✓		Rad gauge	
2.13	+/- .030	2.130	✓		SL10	
R.41	+/- .030	.410	✓		Rad gauge	
R.50	+/- .030	.500	✓		"	
1.22	+/- .030	1.220	✓		SL10	
R.50	+/- .030	.500	✓		Rad gauge	
.03X45°	+/- .030 X .5°	.030	✓		SL10	
1.10	+/- .030	1.101	✓			
.550	+/- .010	.549	✓			
1.18	+/- .030	1.180	✓			
.49	+/- .030	.487	✓			
R.13	+/- .030	.125	✓		Rad gauge	
.125	+/- .010	.127	✓		SL10	
.20	+/- .030	.200	✓		"	
30°	+/- .5°	30°	✓		Protractor	
1.150	+/- .005	1.150	✓		SL10	
.600	+/- .010	.598	✓		"	
45°	+/- .5°	45°	✓		Protractor	
φ .098	+ .004 / - .001	.097	✓		SL10	
.17	+/- .030	.170	✓		"	
7/16-20 UNF	—	7/16-20	✓		Thread gauge	
.63 Deep	+/- .030	.630	✓		SL10	
7/16-20 UNF	— DAS	7/16-20	✓ DAS		Thread gauge	

Measured by: 20 9-89	Checked by: 14 9-89	QC Inspector:
Date: 19-09-03	Date: 19/09/11	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					